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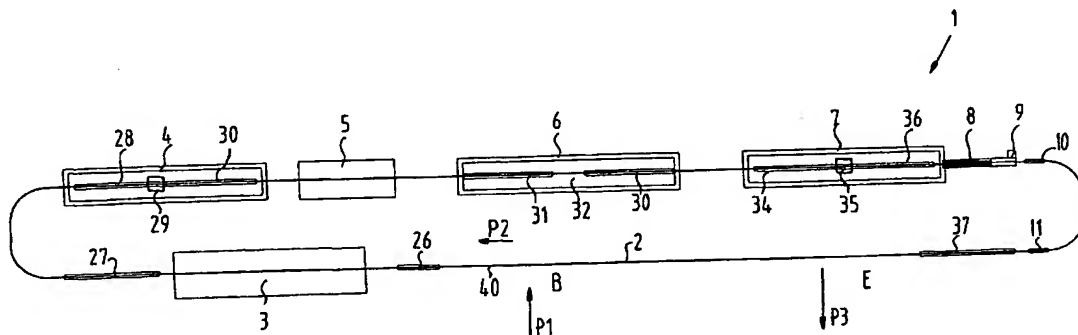
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(54) Title: METHOD AND DEVICE FOR GALVANIZING OBJECTS



(57) Abstract: The present invention relates to a method for thermally galvanizing objects, in particular metal objects, comprising the steps of: pretreating an object for treating, including removing the surface layer from the object; arranging the pretreated object in a flux bath for fluxing of the object; arranging the fluxed object in a zinc bath in order to have the material of the object react with zinc and to apply a zinc-containing layer to the object, wherein the step of pretreating comprises of blasting the object with grains so as to remove at least the surface layer. The invention also relates to a device for shot-blasting objects, in particular as pretreatment in the galvanizing of the object.

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METHOD AND DEVICE FOR GALVANIZING OBJECTS

The present invention relates to a method and device for galvanizing objects, in particular galvanizing metal objects.

A number of techniques are known for the protection of steel constructions from the effect of corrosion. One known technique is hot dipping galvanizing, wherein a thin layer of zinc is applied to the object surface. The applied zinc layer provides the object with a cathodic protection; i.e. in the case of corrosion zinc is relinquished and thus protects the underlying metal. The corrosion products of zinc will moreover fill up possible damage such as scratches and the like, whereby an additional protection is obtained.

The zinc can be deposited by electrochemical means onto the object, this being known as electrolytic galvanization. In addition, the zinc can be applied to the metal object by spraying zinc onto the surface of the object using spray guns (zinc-spraying), by having zinc diffuse in a drum (sherardizing) or by painting the zinc onto the object (referred to as zinc dust painting or cold-galvanizing). A further option for applying zinc to a metal is thermal galvanizing, wherein the object for treating is immersed in liquid zinc located in a zinc bath at temperatures between 445°C and 465°C.

In thermal galvanizing the object for treating undergoes a pretreatment in which dirt, oil and fat residues are removed from the object surface. As pretreatment the object is then placed in a bath with a diluted hydrochloric acid solution and pickled therein so as to remove rust and mill scale. There then follows a "flux" treatment in which the object for treating is

arranged in a flux bath with for instance zinc ammonium chloride so as to later obtain a good adhesion of the zinc to the steel. If the flux is first applied and then dried, this is known as dry galvanizing. In wet
5 galvanizing the flux is spread over the zinc bath surface and the steel is pulled therethrough. After the treatment there is formed on the steel surface an entity of zinc/iron alloy layers. After said pretreatment the object is immersed, in accordance with the known method,
10 for some minutes in the zinc bath where the liquid zinc bonds to the steel, this over the entire surface thereof and therefore also on the inside of possible hollow structures in the object. During the immersion a number of (gamma, delta and eta layer) alloy layers are formed
15 through reaction of zinc with metal, while a layer of pure zinc is formed when the object is taken out of the zinc bath.

A number of drawbacks are associated with the known methods. Firstly, the use of chemical baths such as
20 hydrochloric acid baths as pretreatment of the steel has an environmental impact. In addition, the supply of hydrochloric acid and the discharge of (contaminated) hydrochloric acid entails high costs.

The known method further involves a number of
25 labour-intensive and relatively costly steps, such as the arranging of the steel in degreasing baths, pickling baths and possible dezincification baths in the case of reconditioning of steel once galvanized in the past. The hydrochloric acid after all only removes the mill scale
30 from the object and further impurities remain present on the object surface. Additional processing steps are hereby necessary.

A further drawback of the known method and device is that the use of hydrochloric acid results in
35 brittleness of the treated metal. Subsequent galvanizing

of the brittle metal will therefore produce a less smooth surface, which adversely affects the appearance of the galvanized product.

Known from the American document US 5,666,714 is a method for galvanizing steel components. The components are first shot-blasted and are then formed and/or welded into an object. The thus formed and/or welded object undergoes, among others, a flux treatment and a galvanizing treatment. A drawback of the known method is that prefabricated and/or used objects first have to be taken apart into their individual components to enable the start of pretreatment of the components.

An object of the invention is to obviate the above stated drawbacks and to provide an improved method, system and device for treating objects with a protective material.

It is another object of the invention to provide an advantageous device with which objects for galvanizing can be pretreated.

According to a first aspect of the invention a method is provided for this purpose for thermally galvanizing objects, in particular metal objects, comprising the steps of:

- pretreating an object for treating, including removing the surface layer from the object;
- arranging the pretreated object in a flux bath for fluxing of the object;
- arranging the fluxed object in a zinc bath in order to have the material of the object react with zinc and to apply a zinc-containing layer to the object, wherein the step of pretreating comprises of blasting the object with grains so as to remove at least the surface layer. According to this aspect of the invention the pretreatment steps of optional dezincification, the degreasing, the treatment with hydrochloric acid and the

cleaning with water and the like can therefore be replaced by a single step, i.e. shot-blasting of the object. Not only is the mill scale here removed from the object, but it is also possible, as desired, to remove multiple material layers, such as the silicon layer, from the object. This produces a cleaner surface of the object, which surface requires a smaller quantity of zinc for the purpose of galvanization. The thus treated object is further more suitable for the application thereto of a coating. The appearance of an object shot-blasted and galvanized in this manner is also more attractive.

The method according to the invention is further directly applicable to prefabricated objects and/or even to already used objects. The objects can herein be treated immediately without additional steps such as dismantling and the like therein being necessary.

It has been found that particles or grains with an average diameter of between 0.25 and 1.6 mm and manufactured from steel with a low carbon content are particularly suitable for shot-blasting the objects. The grains have a low carbon content since, with a high carbon content, too thick a zinc layer is deposited onto the object and the degree of hard zinc formation increases. A mixture is preferably applied of substantially 40% with a grain size of 0.6-1.0 mm and 60% with a grain size of 0.8-1.3 mm. This makes possible an optimal ratio between toughness, minimum grain use and maximum effect. A large ricochet/bounce effect also occurs which increases the effectiveness of the shot-blasting, and particularly the blasting of the parts of the object which are relatively difficult to reach.

It is deemed known to immerse an object for treating in a bath, to subsequently hold it stationary in the bath for a few minutes and then remove it from

the bath. It is then the turn of the following object. According to a further preferred embodiment of the invention however, the above stated step of arranging the object in at least one of the baths comprises of having the object move through the bath in question. This means that one object after another can be transported continuously or in substantially uninterrupted manner through the bath. This not only makes possible the use of a device as according to the aspect of the invention to be mentioned below, but also influences chemical processes which occur during the galvanization. This immersion or plunging of the objects into a bath influences the occurring chemical processes in negative manner. By moving the objects through the bath there is less ash formation and, in particular, less vapour formation. There is moreover a smaller chance of loss-making formation of hard zinc iron/zinc crystals.

An object is preferably transported through the bath at a practically constant speed in order to bring about a uniform galvanization of the object which is as constant as possible.

According to a second aspect of the invention, there is provided a device for shot-blasting objects, in particular metal objects, comprising:

- a housing provided with at least an entrance opening and exit opening for supplying respectively discharging the objects for shot-blasting;
- displacing means for displacing the objects for shot-blasting in a path through the housing from the entrance opening to the exit opening;
- shot-blasters which are disposed on both sides along the path in the housing and are oriented differently in relation to the housing, and which hurl streams of grains at an object in a number of different

blasting directions for the purpose of removing a surface layer from the object over substantially the whole surface thereof. The shot-blasters therefore direct grains simultaneously to at least the front and the rear of the object, this at different angles, so that the grains strike the object everywhere. In the embodiment most recommended at this moment, eight shot-blasters are placed and directed such that all those parts of the objects for processing which have to reached can be reached.

In a preferred embodiment of the invention the displacing means comprise:

- a beam extending along the route,
 - one or more suspension elements which can be fixed to the beam and from which the objects for displacing can be suspended;
 - drive means for displacing the suspension elements along the beam;
 - a first guide element placed on a first side along the route;
 - a second guide element placed on an opposite side along the route,
- wherein the mutual distance between the first and second guide element is adjusted to the dimensions of the object. In a particular preferred embodiment a suspension element engages on the top side of an object and the guide elements are disposed to limit the transverse displacement of the underside of the object. The guide means ensure that, despite the great forces exerted on the objects by the shot-blasters, as a result of which the objects could be blown into an askew position, the objects remain in upright orientation in the correct manner. This ensures a uniform removal of the surface layer from the objects. Application of the beam (preferably in the form of an overhead track) along

which the objects are transported continuously during the treatment process (galvanizing process) furthermore enables the process to be fully automated, or at least to a large extent. This allows a better control of the different process steps, while less personnel is required.

In a further preferred embodiment the device is suitable for shot-blasting objects of different dimensions and forms. The embodiment is adapted for fixing of the guide elements at different intermediate distances, depending on the dimensions of the object. In the case of relatively large objects or objects with protruding parts, a large intermediate distance is opted for, while in the case of relatively small objects the intermediate distance can be small.

A distance of less than 30 cm is preferably kept between the object and the guide element. If the form of the object permits, an even smaller distance is chosen, such as for instance 10 cm.

In another preferred embodiment the dimensions of the entrance and exit opening are adjustable. In the case of large objects a relatively large opening is necessary, while a relatively small opening can suffice for small objects. Making the openings larger and smaller can take place by providing the housing with a number of doors slidable relative to each other. The entrance opening is for instance formed by two sliding doors between which the opening is defined. The opening is chosen such that the relevant object can just enter or leave the housing through the opening. This limits the quantity of grains released during the shot-blasting, which enhances the treatment of the object. Grains escaping from the housing (blasting cabinet) can after all enter the flux baths or zinc baths, and thus adversely affect the fluxing or galvanizing process.

A further preferred embodiment comprises first detection means positioned close to the entrance opening with which the dimensions of the following object for shot-blasting can be determined, in addition to control means which are coupled to the detection means and with which the size of the entrance opening and exit opening can be set subject to the detected object size. An automatic adjustment of the size of the entrance opening and/or exit opening can hereby be realized.

10 A further preferred embodiment comprises second detection means for detecting an object hanging from one of the suspension elements, in addition to control means for controlling the drive means of the overhead track and at least the shot-blasters in order to interrupt the driving of the suspension element and the shot-blasters with a predetermined time delay. When for instance one or more detection eyes detect that the supplied suspension elements no longer contain any objects for treating, the control means can then determine when the blasting process must be ended on the basis of the transport speed, known in advance, of the suspension elements. It is furthermore possible to determine when the last object has been fully processed. At that moment the driving of the overhead track is also ended.

25 According to a third aspect of the invention, there is provided a system for thermally galvanizing objects, in particular metal objects, comprising an overhead track provided with suspension elements from which one or more objects for treating can be suspended, in addition to drive means for displacing the suspension elements along the overhead track, wherein there are disposed along the overhead track at least: shot-blasters for hurling one or more streams of grains in the direction of an object being displaced therealong for the purpose of removing at least the surface layer

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from the object; a flux bath for fluxing the object displacing through the bath; and a galvanizing bath for thermally galvanizing the object displacing through the bath. The shot-blasting of the objects instead of
5 degreasing, hydrochloric acid treatment and cleaning with water provides the above described advantages. Furthermore, the overhead track along which the objects are transported continuously during the galvanization process allows the galvanization process to be automated
10 fully, or at least to a large degree. This enables a better control of the different process steps, while up to 80% less personnel is required.

According to a preferred embodiment, the overhead track is embodied with at least one descending part and
15 at least one ascending part for respectively carrying the objects downward into a bath and upward out of the bath. A substantially constant treatment of the objects in the flux bath and/or the zinc bath is hereby possible with a relatively simple construction.

20 According to a further aspect of the invention a suspension element is provided, preferably the above mentioned suspension element, which is manufactured from an alloy such that substantially no zinc is absorbed or adheres to the surface of the element. When a suspension
25 element is guided along the zinc bath, zinc could otherwise be left on the surface of the suspension element. In the processing of a following object this can result in explosions, particularly during shot-blasting of this object, which can cause a hazard for
30 men and machines. An explosion can occur in the system if zinc residues mix with steel grains of another composition (metals).

Further advantages, features and details of the present invention will be elucidated on the basis of the
35 following description of a preferred embodiment thereof.

Reference is made in the description to the annexed figures, in which:

Figure 1 shows a schematic top view of a preferred embodiment of the invention;

5 Figures 2a and 2b show schematic side views of the preferred embodiment of figure 1;

Figure 3 shows a schematic perspective view of a preferred embodiment of a blasting cabinet according to the invention;

10 Figure 4 shows a more detailed and partly cut-away perspective view of the blasting cabinet of figure 3; and

Figure 5 shows a further cut-away view in perspective in which the guiding of the objects is
15 further illustrated.

Figures 1 and 2 show the preferred embodiment of a galvanizing device 1 according to the invention. The objects for galvanizing V, such as for instance steel sections, are supplied and coupled at a starting
20 position to a transport system. The transport system is an overhead track system and in the shown embodiment comprises a chain box rail 2 along which, using rollers 21 (figure 2a), a number of (for instance about 100) suspension elements 22 can be displaced at an
25 intermediate distance of about 60 cm. Such a chain box rail system is of a conventional type per se and will not be discussed here in detail. Other transport systems can also be envisaged.

The suspension elements 22 are advanced by a drive
30 8 connected to an electrical drive motor 9. Transport system 2 is provided with two tensioning elements 10 and 11 in order to place the system permanently under a determined tension.

Once the objects for treating V have been fastened
35 to suspension elements 22 at starting point B (arrow P₁),

for instance by hooking the objects thereto, the suspension elements are transported in the direction of arrow P_2 .

The untreated object V first undergoes a shot-
5 blasting treatment in a blasting cabinet 3. Objects are shot-blasted in the blasting cabinet by means of a number of shot-blasters disposed at a preset angle. Not only is the blasting angle at which the objects are blasted important here, so also are the grain diameter
10 and the material of the grains. It has been found that an optimum removal of the surface layer from the object can be achieved with the use of steel grains or other forms of steel particle with a grain thickness of between 0.25 mm and 1.6 mm, and preferably in a ratio of
15 40% particles with a grain size of 0.6-1.0 mm and 60% particles with a grain size of 0.8-1.3 mm. A good chemical composition of the grains is for instance 0.14-0.18% C, 0.65-0.85% Si and 0.35-0.55% Mn. It is possible here to opt for the removal of only the mill scale
20 present on the object. In that case the term surface layer is understood to mean only the mill scale of the object in question. If desirable however, more layers can be removed from the object in addition to the mill scale. It is possible for instance to remove undesired
25 unevenness from the object so that it acquires a smoother and more attractive appearance.

By shot-blasting the object in the above stated manner it is clean to the extent that it can be "fluxed" immediately without additional operations. The term
30 "flux" relates to the arranging of an object in a flux bath which is for instance filled with zinc ammonium chloride. The fluxing agent must be substantially smoke-free, i.e. a proportionally small concentration of ammonium chloride, preferably somewhere in the order of
35 10% NH_4Cl (and about 90% $ZnCl_2$), is applied. The zinc

ammonium chloride forms a thin layer on the object which during the subsequent galvanizing process enhances the bonding of zinc to the material of the object. Figure 2a shows that fluxing takes place by displacing the object, hanging from a suspension element 22, through a flux bath 4.

In another preferred embodiment not shown in the figures, immediately after the shot-blasting and therefore before the fluxing, the object is cleaned by first of all blowing it off with air and/or then spraying it clean with water to which chemical additives have optionally been added. Chemical additives are added to enhance drain-off of the water with the dust which has been left behind, consisting mainly of shot-blasting dust.

Spray cleaning takes place by arranging a number of showers along the conveyor track which remove the final iron residues resulting from the shot-blasting treatment. The mixture of water (optionally with additives) and iron residues is then collected and the iron is removed by applying a magnetic filter. The water can then be reused for spray cleaning. Owing to such a recovery, no iron residues enter the environment. Furthermore, no iron residues enter the flux bath and/or zinc bath (to be discussed later), so that these baths need changing less frequently. These are further environmentally-friendly aspects of the present invention.

Once the flux layer on the object has dried, for instance by guiding the object along a drying unit 5, the object is guided through a zinc bath 6 (figure 2a) which is filled with zinc at a temperature of roughly 453°C. It has been found that at this temperature and at a transporting speed through the zinc bath in the order of magnitude of 50-250 cm per minute, and preferably 80

cm per minute, there is brought about an optimal chemical bonding of the liquid zinc to the material of the object.

The thus formed zinc layer is of complicated structure. In addition to a pure zinc layer on the surface, a number of alloy layers with zinc and iron in differing ratios are also formed between the zinc and the material of the object. The combined layer thickness of these layers varies between 50 and 150 micrometres.

As the galvanized objects emerge, compressed air is guided in the direction of the objects. This can take place for instance by providing a perforated construction adjacently of the conveyor track and by blowing air with great force through the perforations. Zinc droplets possibly still present on the object are hereby blown off the object. This is important if the tolerances in the dimensions of the object are critical, for instance in controlling the fitting of the object. The blown-off zinc droplets are collected and fed back to the zinc bath, whereby excess zinc is saved and less zinc is therefore lost during galvanizing.

After undergoing the galvanizing treatment, the objects cool through heat exchange with the environment such as outside air or heat exchange in an (optional) cooling system. In the shown embodiment the cooling system comprises a cooling bath 7 along which the objects can be carried.

The objects are cooled from about 453°C to about 85°C. If one or more heat exchangers are applied, a temperature of about 80°C can be obtained. In the embodiment shown in figure 2, the cooling is carried out in a cooling bath. Separately of or combined with this cooling bath there can be provided a burnishing bath in which brightener is applied over the surface of the galvanized object in order to give the object surface a

bright appearance. A combined coolant/brightener is preferably Karizol 2508 from the company Dipl. Ing. Herwig GmbH. Such a brightener has good cooling properties, while it also prevents so-called white rusting and makes for an attractive, highly polished product. After cooling and optionally being provided with brightener, the object in question is transported until it reaches end point E. Arriving here, the object can be removed from the relevant suspension element 22 and discharged (P_3). Since the temperature of the objects is about 85°C or less, employees can package the treated objects immediately and without problem.

Figures 2a and 2b show a side view of a part of the device. In the shown embodiment the blasting and fluxing take place one immediately after the other, in contrast to the embodiment of figure 1. This is not relevant however to the description of the invention. As shown in figure 2a, objects V are shot-blasted with a number of blasting elements or shot-blasters 24 which are positioned such that all corners and holes in the objects can be shot-blasted. Shot-blasting therefore takes place not only on the outside but also on the inside of an internal structure of the object, to the extent at least that this internal structure can be reached from outside.

In figures 1 and 2 can be seen that the rail system 21 of transport system 2 has ascending and descending parts at a number of positions. At the starting point (B), where the objects are fastened to the suspension system, the height of rail 21 above the floor amounts to about 2.3 m. At the position of an ascending part 26 of rail 20 the height increases from 2.3 m to about 3 m, so that shot-blasting of the objects takes place at this height. At part 27 there is then a further rise from 3 m to about 5.3 m. Arriving at flux bath 4, there is first

a fall (part 28) so that the objects enter flux bath 4 gradually. At the position of part 29 there is a horizontal displacement, while at the position of part 30 there is once again a rise in order to lift the objects gradually out of flux bath 4. After being dried in drier 5, there is a fall, a horizontal displacement and a rise at the respective parts 31, 32 and 33, so that the relevant object is pulled gradually through the galvanizing bath 6. In similar manner there is a fall, a horizontal displacement and a rise of the object at the parts 33, 34 and 35 of rail 20 in order to cool and optionally provide the object with brightener. Finally, at part 36 there is a fall from about 5.3 m to 3.0 m, so that at the end point the objects can be easily removed from the relevant suspension element 22 (arrow P₃).

The running time of the system, i.e. the period of time between fastening of an object for treating to a suspension element and the removal of a treated object from the suspension element, amounts in the shown embodiment to about 1.5 hours, while the capacity is variable between about 3000 and 3750 kg per hour.

Figure 3 shows a preferred embodiment of the blasting cabinet. The blasting cabinet is constructed from a casing 38 provided with an entrance opening 39 and an exit opening 40. The objects V can be carried inside via the entrance opening and carried out again via the exit opening. In order to ensure that the fewest possible grains escape from the casing, the form of the entrance and exit openings can be adapted to the form of the objects being treated at that moment. In the case of voluminous objects the entrance and exit openings are enlarged to for instance a width W of 60 cm, while for smaller objects the opening can be made smaller to for instance a width W of about 20 cm.

In the shown embodiment a number of detection eyes 41 are arranged which detects the presence or absence of an object V on a suspension element 22. Depending on whether or not an object is detected, a central control (not shown) of the device can control the transport of suspension elements 22 and/or the operation of blasting cabinet 3. It is also possible to control the other elements of the system subject to the detection result, i.e. among others the flux bath 8 and the galvanizing bath (not shown). This allows (fully) automatic galvanizing of the objects.

In another embodiment a number of detection eyes 42 are arranged with which can be determined the dimensions of the object which is about to enter blasting cabinet 3 at that moment. The gap W made available can then be adjusted depending on the dimensions of the object, for instance by sliding the sliding doors 51 and 52 relative to each other.

In figures 4 and 5 the shot-blasting device is shown in more detail. Suspension element 55 comprises a number of rollers 56 and a frame 64. An object V is hung on the frame 64. Suspension element 55 is displaceable with rollers 56 along a track 63. In order to hold the object in upright position when the shot-blasters 60 are hurling streams of grains against the object with great force, there is provided an upper and a lower guiding. At the top the guiding consists of a beam 65 which can be guided in a slot in a component 77 of the blasting cabinet. The slot is dimensioned herein such that beam 65 is displaceable thereby in longitudinal direction, while too great a displacement in transverse direction is prevented. The guiding on the underside of object V comprises a first guide rail 83 and a second guide rail 84, wherein the second guide rail extends parallel to and at a mutual spacing G relative to the first guide

rail. During the transport along the path through the cabinet the lower part of object V is enclosed between the two guide rails 73 and 74. The choice of distance G is slightly greater here than the relevant dimension of the object (in the shown embodiment the depth of the object V). The distance G is usually chosen to be a maximum of 10 cm greater than the relevant dimension of the object, so that the object V can only be displaced a few centimetres in transverse direction (transverse direction P_2) under the influence of the blasting grains.

The mutual spacing G between guide rails 73 and 74 can be adapted to the dimensions of object V. Guide rails 73,74 are arranged for this purpose on supports 75. Supports 75 are provided with a large number of openings 76 into which the guide rails 73,74 can be screwed fixedly.

In a further preferred embodiment the shot-blasting capacity and/or the running speed can be adjusted. Depending on the degree of rust formation on the objects for treating, the shot-blasting capacity (the quantity of grains per unit of time, the blasting angles, the force with which the grains strike the objects etc.) has to be varied subject to the running speed of the transport system. This can take place for instance by making use of a frequency control mechanism.

The suspension elements must moreover be able to change position in fully automatic manner during the displacement along the transport system, this such that the quality of the zinc layer is enhanced and the running speed is high. The position of the suspension hooks is adapted subject to the process an object is undergoing at a given position and a given moment in the transport system. The position of the suspension hooks (length about 60 cm) is adapted by providing at the correct positions in the transport system automatic

rotation points which cause a suspension hook to change position as it is transported therealong.

In another preferred embodiment of the present invention not shown in the figures, a conveyor track of another type is provided. In this conveyor track the objects for galvanizing, after a substantially horizontal displacement along the conveyor track, are moved downward substantially vertically into the flux bath, the galvanizing bath or the cooling bath. After a given time the object is once again moved substantially vertically upward, whereafter the substantially horizontal displacement of the object is continued. This embodiment has the advantage that the height required for the conveyor track is smaller than is the case in the previously mentioned conveyor track. Application of a conveyor track according to the present embodiment further means that the diverse baths require a less long form, since a horizontal displacement of the object in the relevant bath does not have to be taken into account. The capacity of the system can hereby increase to about 5500 kg processed material per hour.

The present invention is not limited to the above described preferred embodiments thereof; the rights sought are defined by the following claims, within the scope of which many modifications can be envisaged.

CLAIMS

1. Method for thermally galvanizing objects, in particular metal objects, comprising the steps of:

- pretreating an object for treating, including removing the surface layer from the object;

5 - arranging the pretreated object in a flux bath for fluxing of the object;

- arranging the fluxed object in a zinc bath in order to have the material of the object react with zinc and to apply a zinc-containing layer to the object,

10 wherein the step of pretreating comprises of blasting the object with grains so as to remove at least the surface layer.

2. Method as claimed in claim 1, wherein the average diameter of the grains amounts to between 0.25
15 and 1.6 mm.

3. Method as claimed in claim 1 or 2, wherein about 40% of the grains has an average grain size of 0.6-1.0 mm and 60% of the grains has an average grain size of 0.8-1.3 mm.

20 4. Method as claimed in claim 1, 2 or 3, wherein the grains are manufactured from steel with a low carbon content, preferably less than 0.18% by weight.

5. Method as claimed in claim 1, wherein between the step of shot-blasting and the step of fluxing the
25 object is blown clean with air and/or is sprayed clean with liquid.

6. Method as claimed in claim 5, wherein the liquid is water to which chemical additives are preferably added to enhance draining of the liquid from the object.

30 7. Method as claimed in any of the foregoing claims, wherein after the step of galvanizing air is

guided along the object to blow off zinc droplets on the object.

8. Method as claimed in claim 7, comprising of feeding the blown-off zinc droplets back into the zinc bath.

9. Method as claimed in any of the claims 1-8, wherein the step of arranging the object in at least one of the baths comprises of having the object move through the bath in question.

10. Method as claimed in claim 9, comprising of transporting the object in substantially uninterrupted manner through the bath.

11. Method as claimed in claim 9 or 10, comprising of transporting the object through the bath at practically constant speed.

12. Method as claimed in claim 11, wherein the transporting speed through the zinc bath is in the order of magnitude of 50 to 250 cm, and preferably 80 cm, per minute.

13. Method as claimed in any of the foregoing claims, comprising of drying the fluxed object.

14. Method as claimed in any of the foregoing claims, comprising of cooling the object provided with a zinc layer.

15. Method as claimed in any of the foregoing claims, comprising of subjecting the object provided with a zinc layer to a burnishing treatment.

16. System for thermally galvanizing objects, in particular metal objects, comprising an overhead track provided with suspension elements from which one or more objects for treating can be suspended, in addition to drive means for displacing the suspension elements along the overhead track, wherein there are disposed along the overhead track at least:

- one or more shot-blasters for hurling one or more streams of grains in the direction of an object being displaced therealong for the purpose of removing at least the surface layer from the object;

5 - a flux bath for fluxing the object displacing through the bath;

- a galvanizing bath for thermally galvanizing the object displacing through the bath.

10 17. System as claimed in claim 16, wherein the shot-blasters are disposed to blast the object for treating at a number of predetermined blasting angles.

15 18. System as claimed in claim 17, wherein the shot-blasters are disposed in a casing, the dimensions of the entrance and exit opening of which are adjustable depending on the form and dimensions of the objects displacing through the casing.

20 19. System as claimed in claim 16, 17 or 18, wherein the overhead track is embodied with at least one descending part and at least one ascending part for respectively carrying the objects downward into a bath and upward out of the bath.

25 20. System as claimed in any of the claims 16-19, comprising detection means for detecting an object hanging from one of the suspension elements, in addition to control means for controlling the drive means of the overhead track and at least the shot-blasters in order to interrupt the driving of the suspension element and the shot-blasters with a predetermined time delay.

30 21. System as claimed in any of the claims 16-20, comprising means for drying the objects, means for cooling the objects and/or means for burnishing the objects.

35 22. System as claimed in any of the claims 16-21, wherein cleaning means are provided between the blasting means and the flux bath for blowing the object clean

with air and/or removing material residues from the object with liquid.

23. System as claimed in claim 22, comprising collecting means for collecting the mixture of material residues and air and/or liquid, means for separating the material residues, and means for feeding the air and/or the liquid back to the cleaning means.

24. System as claimed in any of the foregoing claims, wherein means are disposed at a position beyond the galvanizing bath for guiding air along the object so as to blow off zinc droplets on the object.

25. Suspension element for suspending an object in a system as claimed in any of the foregoing claims, wherein the suspension element is manufactured from an alloy such that substantially no zinc is absorbed or adheres to the surface of the element.

26. System as claimed in any of the claims 16-25 which is suitable for performing the method as claimed in any of the claims 1-15.

28. Device for shot-blasting one or more objects, in particular metal objects for galvanizing, comprising:

- a housing provided with an entrance opening and exit opening for supplying respectively discharging the objects for shot-blasting;

- displacing means for displacing the objects for shot-blasting in a path through the housing from the entrance opening to the exit opening;

- shot-blasters which are disposed on both sides along the path in the housing and are oriented differently in relation to the housing, and which hurl streams of grains at an object in a number of different blasting directions for the purpose of removing a surface layer from the object over substantially the whole surface thereof.

29. Device as claimed in claim 28, wherein the displacing means comprise:

- an overhead track extending along the route,
 - one or more suspension elements which can be
5 fixed to the overhead track and from which the objects
for displacing can be suspended;
 - drive means for displacing the suspension
elements along the overhead track;
 - a first guide element placed on a first side
10 along the route;
 - a second guide element placed on an opposite side
along the route,
- wherein the mutual distance between the first and second
guide element is adjusted to the dimensions of the
15 object.

30. Device as claimed in claim 29, wherein the guide elements are adapted for fastening of the guide elements at different intermediate distances, depending on the dimensions of the object.

20 31. Device as claimed in claim 29 or 30, wherein a suspension element engages on the top side of an object and the guide elements are disposed in order to limit the transverse displacement of the underside of the object.

25 32. Device as claimed in claim 29, 30 or 31, wherein said intermediate distance is adjustable to be a maximum of 30 cm, preferably a maximum of 10 cm, greater than the relevant dimension of the object.

30 33. Device as claimed in any of the claims 29-32, wherein the suspension element is manufactured from an alloy such that substantially no zinc is absorbed or adheres to the surface of the element.

34. Device as claimed in any of the foregoing claims 28-33, wherein the size of the entrance and exit
35 openings is adjustable.

35. Device as claimed in claim 34, wherein the entrance opening and/or exit opening is defined by doors slidable relative to each other.

36. Device as claimed in claim 34 or 35, comprising
5 first detection means positioned close to the entrance opening with which the dimensions of the following object for shot-blasting can be determined, in addition to control means which are coupled to the detection means and with which the size of the entrance opening
10 and exit opening can be set subject to the detected object size.

37. Device as claimed in any of the foregoing claims, comprising a number of, preferably four, shot-blasters positioned on one side of the path and a number
15 of, preferably four, shot-blasters positioned on the opposite side of the path.

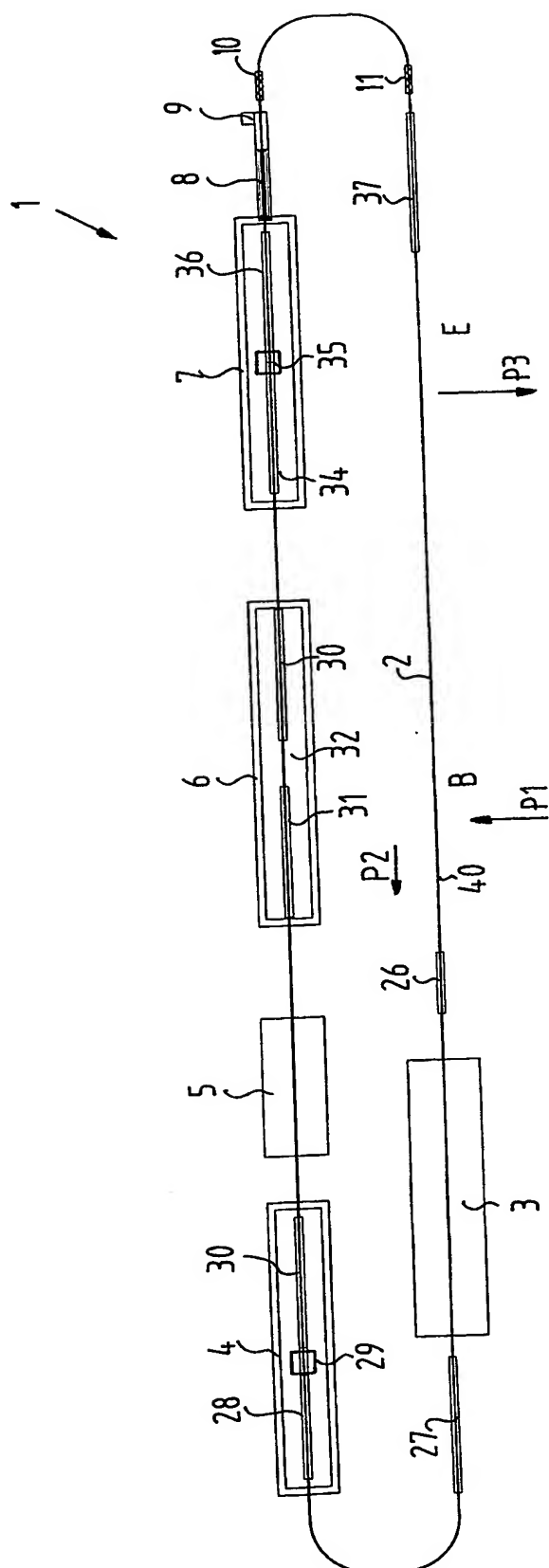
38. Device as claimed in any of the foregoing claims, wherein the shot-blasters are embodied to hurl streams of grains with an average grain diameter between
20 0.25 and 1.6 mm.

39. Device as claimed in any of the foregoing claims, comprising second detection means for detecting an object hanging from one of the suspension elements, in addition to control means for controlling the drive
25 means of the overhead track and at least the shot-blasters in order to interrupt the driving of the suspension element and the shot-blasters with a predetermined time delay.

40. Device as claimed in any of the foregoing
30 claims, comprising control means which are coupled to the shot-blasters and the displacing means and which are adapted to adjust a suitable blasting capacity subject to the running speed produced by the displacing means.

41. Device as claimed in claim 40, wherein the
35 shot-blasting capacity is defined by the quantity of

grains per unit of time, the blasting angles and/or the force with which the grains strike the object.



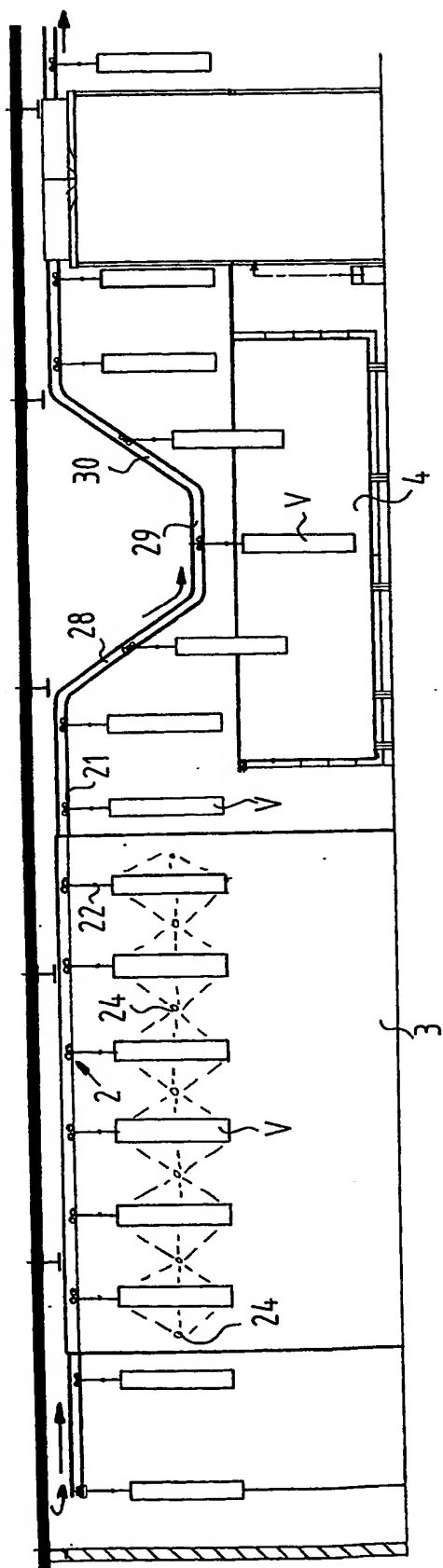


FIG. 2A

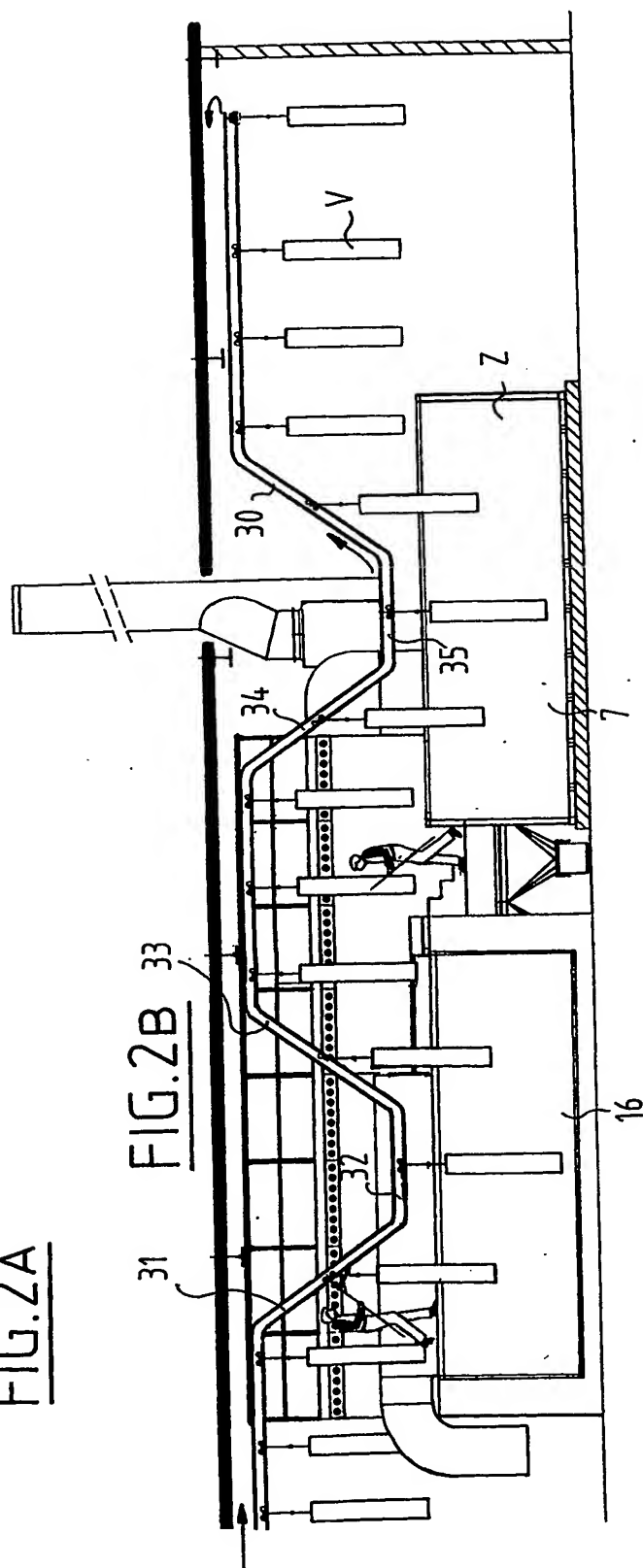
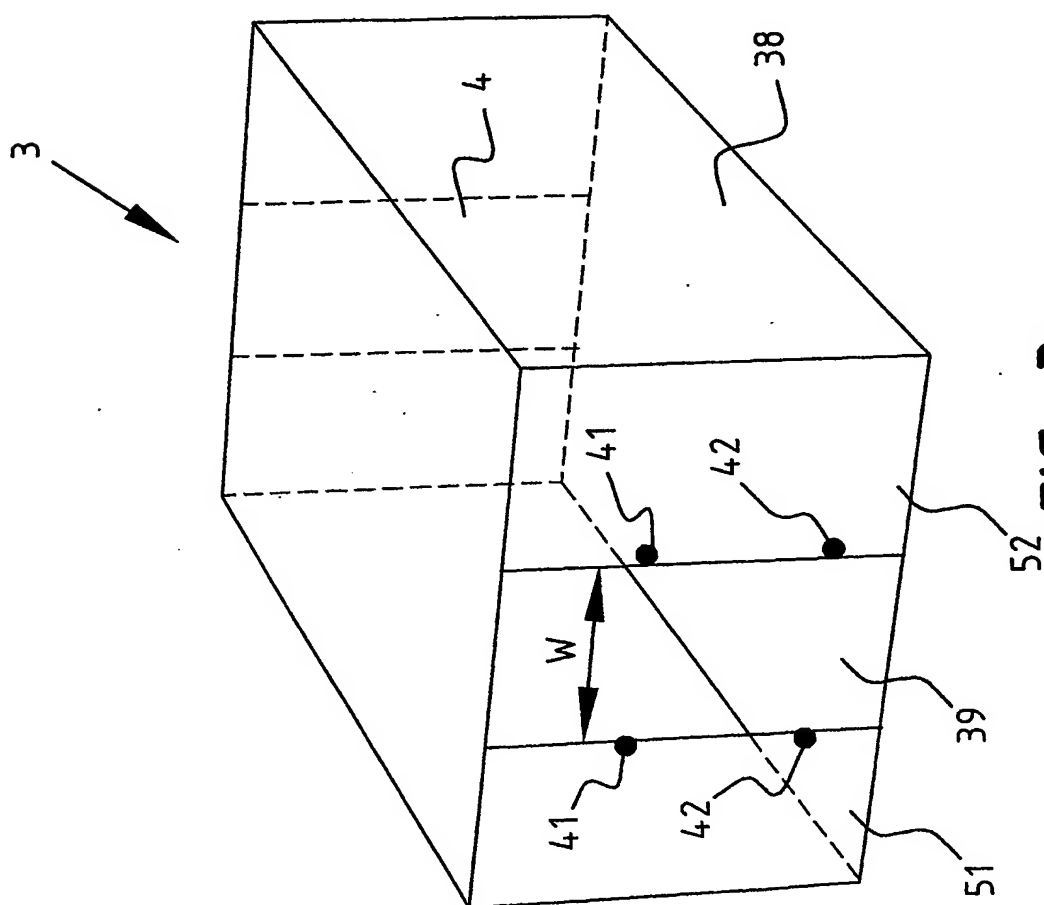
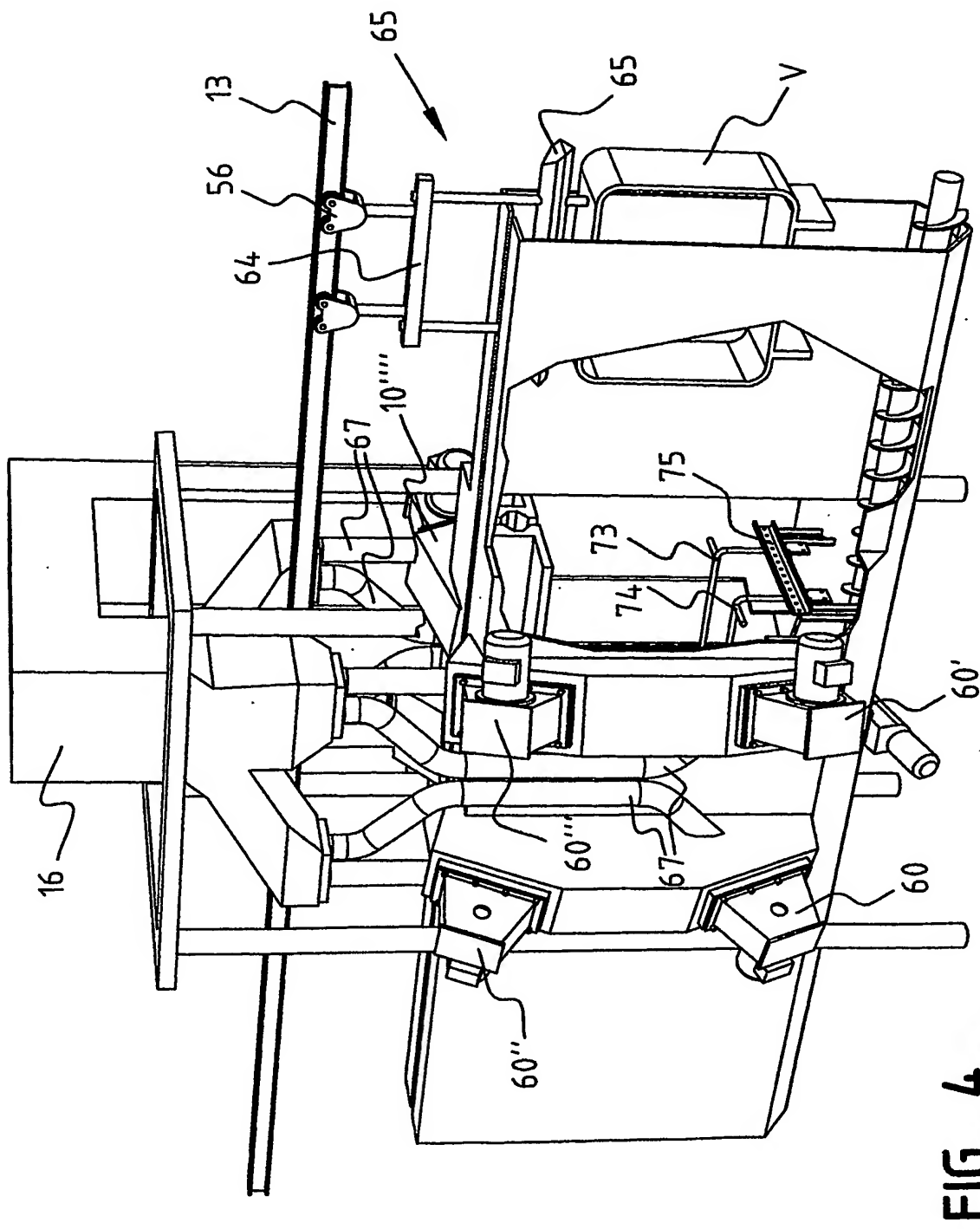


FIG. 2B





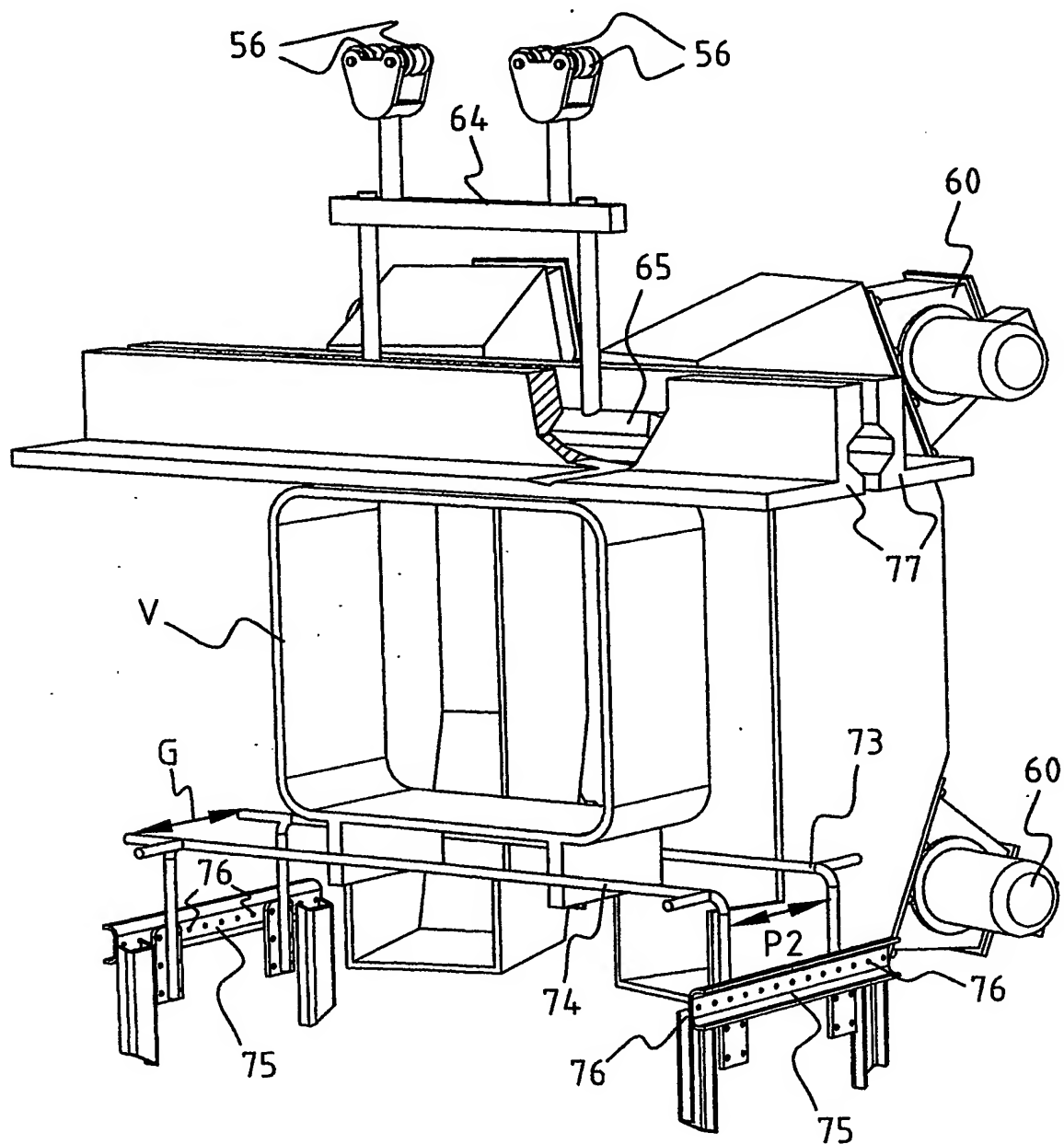


FIG. 5

INTERNATIONAL SEARCH REPORT

PCT/NL 03/00025

A. CLASSIFICATION OF SUBJECT MATTER
 IPC 7 C23C2/02 B24C3/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
 IPC 7 C23C B24C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

PAJ, WPI Data, INSPEC, EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

13 May 2003

Date of mailing of the international search report

23/05/2003

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PCT/NL 89/00025

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